

# Work Order ID 65133

Thursday, January 06, 2011 2:29:09 PM



Page 1

Item ID: D206-667-203TRN

Accept



Setup Start



Revision ID:

Stop



Item Name: Crosstube Turning Detail

Start Date: 1/6/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 1/20/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date: 1/01/11

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D206-667-243	Rev C								

100

0.00



MORI SEIKI CNC LATHE LARGE

Mori Seiki

Memo

0.00

Mori Seiki CNC Lathe Large

1-Fill tube with sand & install plugs DT8534 on both ends as per Folio FA089□2-Turn first side as per Folio FA089□3-File down transition lines smooth.

amh 1/01/26

1 0

110

0.00



QC1- Inspect dimensions to dimension sheet

QC

Memo

0.00

Quality Control

amh 1/01/26

1 0

120

0.00



MORI SEIKI CNC LATHE LARGE

Mori Seiki

Memo

0.00

Mori Seiki CNC Lathe Large

1-Turn second side as per Folio FA089□2-File down transition lines smooth.  
□  
3-Remove sand and plugs□4-Scrib part# and batch #

amh 1/01/27

1 0

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Page 2

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Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130  QC Quality Control	QC1- Inspect dimensions to dimension sheet  Memo	0.00 0.00		2/10/27		1	0		
140  QC Quality Control	QC8- Inspect parts - second check  Memo	0.00 0.00		2L 11/01/27		1			
150  HandFXtube Hand Finishing Crosstubes	Crosstubes Chemical Conversion  Memo	0.00 0.00		BB 11/01/31		1			

W/O:		WORK ORDER CHANGES					
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Page 3

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Accept



Setup Start



Revision ID:

Stop



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Start Date: 1/6/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 1/20/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160



QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

11-1-31

170



Packaging

Packaging

Packaging

Memo

Identify and Stock in kanban rack ☐ Location: 4/6

0.00

0.00

11-1-31

180



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

11/02/02

PL 11-02-1  
(11)

W/O:		WORK ORDER CHANGES					
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**NOTE:** Date & initial all entries

# Picklist Print

Thursday, January 06, 2011 2:29:13 PM

Page 1

Work Order ID: 65133

Parent Item: D206-667-203TRN

Parent Item Name: Crosstube Turning Detail

Start Date: 1/6/2011

Required Date: 1/20/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 08-03-06 new issue DD verified by:ec  
 IPP Rev B 08.04.02 Removed polish EC verified by: DD  
 IPP Rev C 09.01.06 ECN 08-562 EC verified by:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D6004-115		Manufactured	No			100	Each	46.0000	1	1			
-----------	--	--------------	----	--	--	-----	------	---------	---	---	--	--	--



Crosstube Material



Location

Loc Qty

Loc Code

LG

46

34685

15

34774

2

→ 38336

29

1 amb 1/01/26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	65133
<b>Description: Crosstube Assembly</b>	<b>Part Number:</b>	D206-667-243
<b>Inspection Dwg: D206-667-243 Rev: C</b>		<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST

Inspection Sheet	Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
SIDE A	2.490	+0.005/-0.000	2.495	✓		Micr	ML-03
	2.018	+0.005/-0.000	2.023	✓			
	2.079	+0.005/-0.000	2.084	✓			
	2.145	+0.005/-0.000	2.150	✓			
	2.209	+0.005/-0.000	2.213	✓			
	2.287	+0.005/-0.000	2.292	✓			
	2.363	+0.005/-0.000	2.368	✓			
	2.433	+0.005/-0.000	2.438	✓			
	0.200	+/-0.010	.200	✓		Vern	ML-7
	0.500 x 30°	+/-0.010	.500K30°	✓		"	"
	R0.063	+/-0.010	R.063	✓		Rad-gage	REF
	R0.500	+/-0.010	R.500	✓		"	"
	4.438	+/-0.030	4.440	✓		Vern	ML-7
SIDE B	104.91	+/-0.020	104.930	✓		M-tape	ML-2
	2.490	+0.005/-0.000	2.493	✓		Micr	ML-03
	2.018	+0.005/-0.000	2.023	✓			
	2.079	+0.005/-0.000	2.084	✓			
	2.145	+0.005/-0.000	2.149	✓			
	2.209	+0.005/-0.000	2.212	✓			
	2.287	+0.005/-0.000	2.291	✓			
	2.363	+0.005/-0.000	2.368	✓			
	2.433	+0.005/-0.000	2.438	✓			
	0.200	+/-0.010	.205	✓		Vern	ML-7
	0.500 x 30°	+/-0.010	.500K30°	✓		"	"
	R0.063	+/-0.010	R.063	✓		Rad-gage	REF
	R0.500	+/-0.010	R.500	✓		"	"
	4.438	+/-0.030	4.438	✓		Vern	ML-7

<b>Measured by:</b>	<i>[Signature]</i>	<b>Audited by:</b>	<i>[Signature]</i>	<b>Preliminary Approval:</b>	N/A
<b>Date:</b>	11/01/27	<b>Date:</b>	11/01/27	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	06.09.01	New Issue (P/O D206-667-203)	KJ/JLM	<i>[Signature]</i>
B	10.08.25	Dwg Rev updated	KJ	<i>[Signature]</i>

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Item	Qty	Part Number	Description
	-243		
1	X	D206-667-243	CROSSTUBE ASSEMBLY (206L HIGH AFT)
2	1	D6004-115	CROSSTUBE
3	2	D2873-043	NUT PLATE
4	2	D2873-045	NUT PLATE
5	2	D2892-1	SUPPORT
6	4	D3595-063-450	RUBBER CUSHION
7	4	MS21920-22	CLAMP
8	14	MS20601AD4W10	RIVET (OR NAS9302B-4-10)
9	A/R	MAGNOBOND 6398	ROCKWELL SPECIFICATION RBO-120-023 ADHESIVE (TEXTRON/BELL SPEC. 299- 947-100, TYPE II, CLASS 2 ADHESIVE)

# **GENERAL NOTES:**

- 1) MATERIAL: MANUFACTURED FROM D6004-115  
FINISHED LENGTH = 104.91±0.020
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2  
PAINT OUTSIDE PER DART QSI 005 4.2
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED.
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
- 6) IDENTIFICATION: SCRIBE DART PART NUMBER "D206-667-243" AND BATCH NUMBER ON  
INSIDE OF CUFF USING VIBRATING STYLUS.
- 7) WEIGHT: 21.9 lbs
- 8) PART IS SYMMETRIC ABOUT CENTERLINE.
- 9) RUN CUTTER OFF PART WHERE INDICATED. BLEND OUT EDGE LONGITUDINALLY,  
TRANSITION SHOULD BE SMOOTH.
- 10) BEND PROGRESSIVELY WITH A MINIMUM OF 8 PASSES. MAXIMUM TUBE FLATTENING DUE  
TO BENDING IS 6% BASED ON O.D.
- 11) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- 12) INSTALL D2892-1 SUPPORT USING 0.03" TO 0.06" THICK LAYER OF MAGNOBOND 6398 PER  
QSI 015. LET CURE FOR 12 HOURS AFTER INSTALLATION AND PRIOR TO PACKAGING.
- 13) INSTALL MS21920-22 CLAMPS WITH D3595-063-450 RUBBER CUSHIONS TO SECURE THE  
D2892-1 SUPPORT ON TOP SIDE OF THE CROSSTUBE. ENSURE CLAMP MECHANISMS ARE  
LOCATED ON CROSSTUBE SUPPORTS.
- 14) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE  
OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS  
SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT  
LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 15) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS ARE SHOWING IN  
SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING.

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 45133  
PA 11-01-4

RELEASED  
08/11/06

C	REVISE GENERAL NOTES/PART LIST (ZN D7-1); REORGANIZED VIEWS AND REFORMATTED DRAWING TO CURRENT STANDARDS. D3595-063-450 WAS D2856-400-773 (ZN D6-2 & A5-2); REMOVED REF. & ADD TOLERANCES (ZN 4-3, C5-3, D3-3); RELOCATED FLAG #6 (ZN A8-3) PER NCR 210; MOVED TURNING DETAIL & UPDATED TOLERANCE TO SHEET 4.	RF	08.11.06
B	ADD HOLES AND NUT PLATES FOR COMPATABILITY WITH BHT/AA SKUDTUBES	PH	05.07.26
A	NEW ISSUE	CP	00.11.17
REV.	DESCRIPTION	BY	DATE
DESIGN	<u>RF</u>	<b>DART AEROSPACE LTD</b>	
DRAWN	<u>RF</u>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<u>RF</u>	DRAWING NO.	REV. C
MFG. APPR.	<u>RF</u>	D206-667-243	SHEET 1 OF 4
APPROVED	<u>RF</u>	TITLE	SCALE
DE APPR.	<u>RF</u>	CROSSTUBE ASSY (206L HIGH AFT)	NTS
DATE	08.11.06	COPYRIGHT © 2006 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

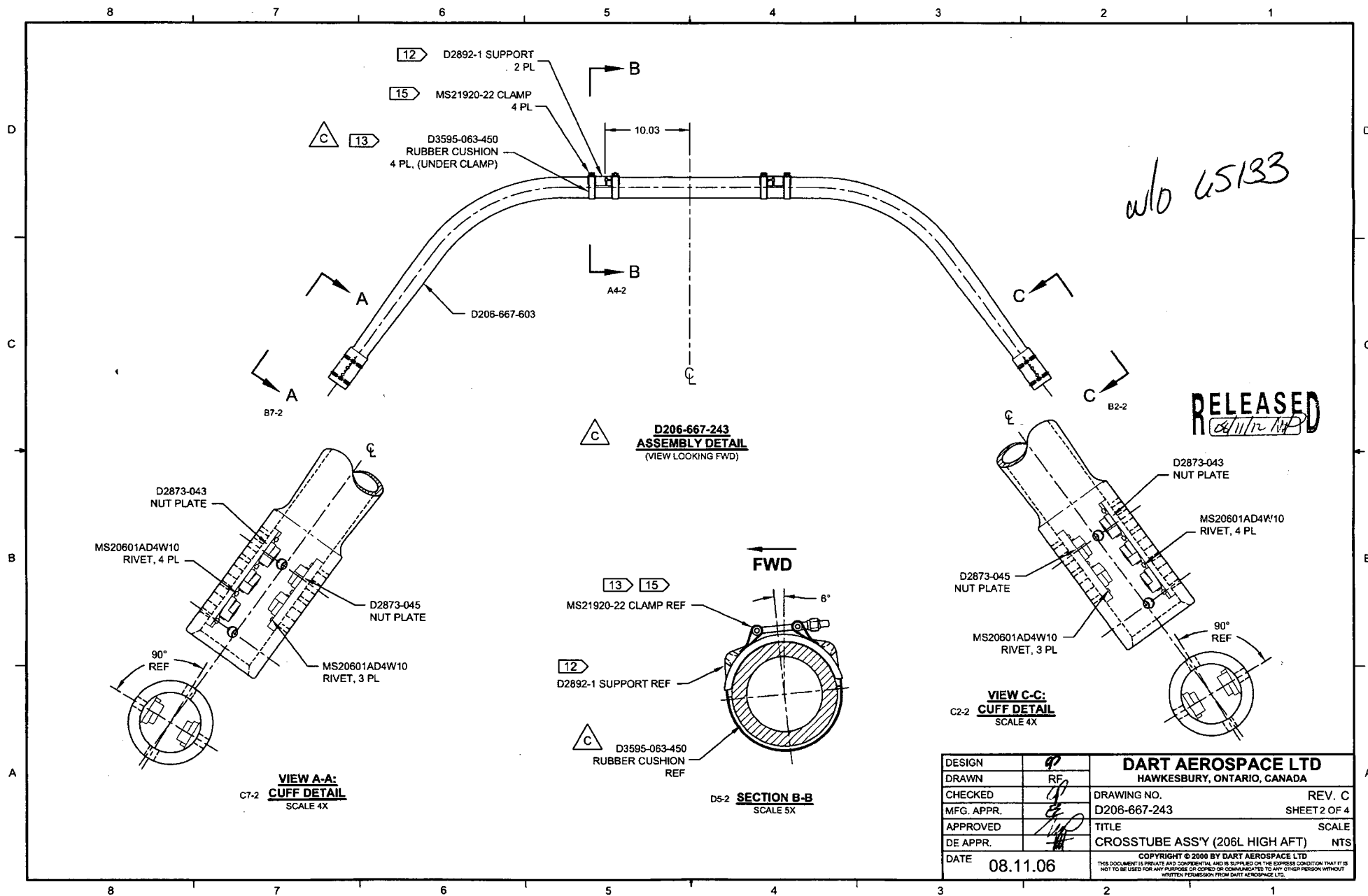
W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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DESIGN	97	<b>DART AEROSPACE LTD</b>	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JP	DRAWING NO.	REV. C
MFG. APPR.	JP	D206-667-243	SHEET 2 OF 4
APPROVED	JP	TITLE	SCALE
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**D206-667-603**  
**BENDING AND DRILLING DETAIL**  
(VIEW LOOKING FWD)

**DETAIL D**  
SCALE 4X  
(VIEW LOOKING FWD)

**DETAIL H**  
SCALE 4X  
(VIEW LOOKING FWD)

**VIEW E-E: CUFF DETAIL**  
SCALE 4X

**VIEW F-F**  
(VIEW LOOKING AFT, ROTATED)

**VIEW J-J**  
(VIEW LOOKING AFT, ROTATED)

**VIEW K-K: CUFF DETAIL**  
SCALE 4X

**SECTION G-G**  
SCALE 5X

DESIGN		DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	CP	DRAWING NO.	REV. C
MFG. APPR.	EP	D206-667-243	SHEET 3 OF 4
APPROVED	MP	TITLE	SCALE
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CHECKED	40	DRAWING NO.	REV. C
MFG. APPR.	40	D206-667-243	SHEET 3 OF 4
APPROVED	40	TITLE	SCALE
DE APPR.	40	CROSSTUBE ASSY (206L HIGH AFT)	NTS
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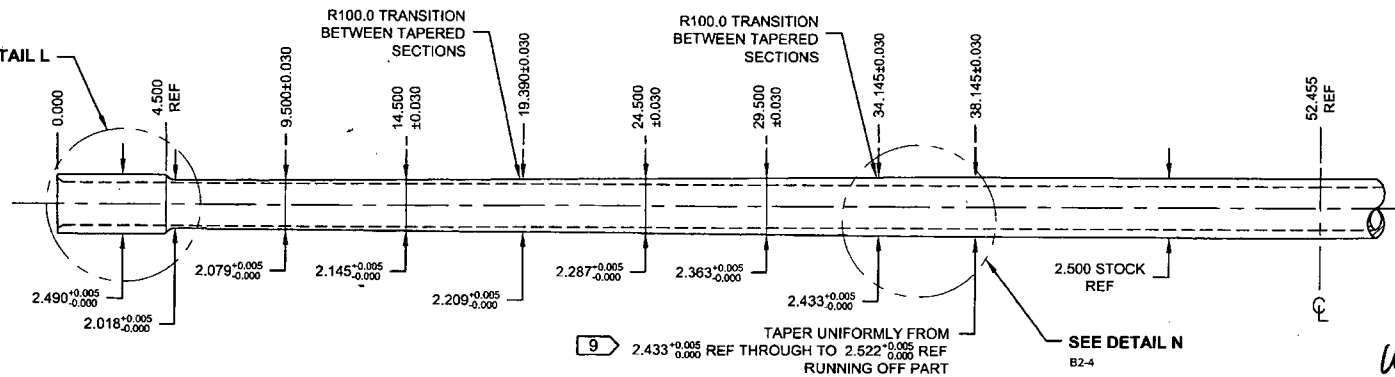
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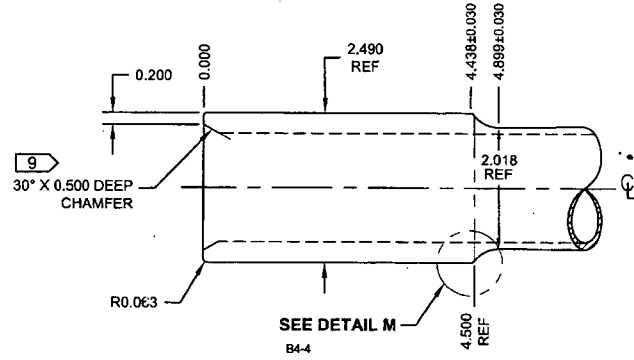


SEE DETAIL L  
B7-4

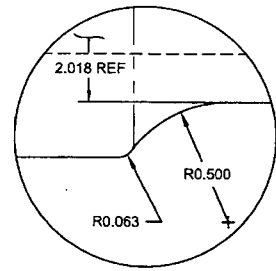


W/065133

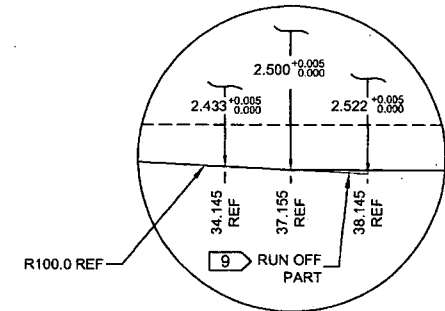
**C TURNING DETAIL**



**DETAIL L: CROSSTUBE CUFF**  
NOT TO SCALE



**DETAIL M: CUFF TRANSITION**  
NOT TO SCALE



**DETAIL N: TAPER RUN-OFF**  
NOT TO SCALE

**RELEASED**  
08/11/06

DESIGN	07	<b>DART AEROSPACE LTD</b>	
DRAWN	RE	HAWKESBURY, ONTARIO, CANADA	
CHECKED	07	DRAWING NO.	REV. C
MFG. APPR.	07	D206-667-243	SHEET 4 OF 4
APPROVED	07	TITLE	SCALE
DE APPR.	07	CROSSTUBE ASSY (206L HIGH AFT)	NTS
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